

Work Order ID 82727

Thursday, April 05, 2012 12:59:00 PM

82727

Page 1

Item ID: D3504-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Crossbolt Spacer

Start Date: 4/5/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 4/13/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan:

Date: 12-04-5 Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3504	Rev C

100

0.00

100

Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

Memo

0.00

1-TURN AS PER FOLIO FA712 & DWG D3504, FOLIO
REV: DWG REV: 2-DEBURR AS REQUIRED

Manual

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

120

0.00

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

12-4-11

12

12-4-12

12

12

EL
in line

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82727

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Page 2

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Stop

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: *SLg*

0.00

130

Packaging

Memo

0.00

Packaging

STOCK IN SKIDTUBE CELL

*12x**SP
12-04-12*

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

*12/4/12**12-04-12*

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Picklist Print

Thursday, April 05, 2012 12:59:08 PM

Page 1

Work Order ID: 82727

82727

Parent Item: D3504-5

D3504-5

Parent Item Name: Crossbolt Spacer

Start Date: 4/5/2012

Required Date: 4/13/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	49.6430	0.3077	3.886737			

M6061T6R0 750

6061-T6 Round Bar .750"

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT012	13.643	
120603	2.043	
120734	11.6	
MAT013	36	
121282	36	

4.0 ~~12~~ 12-4-12

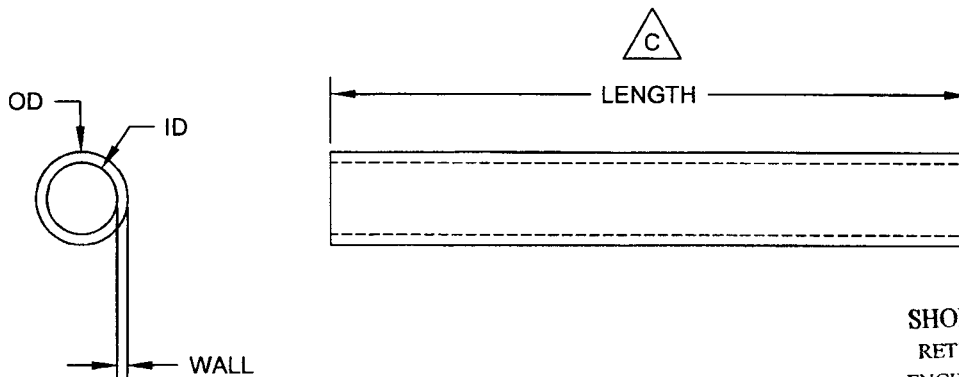
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

D3504-1/-3/-5 CROSS BOLT SPACER PARTS LIST NO. 82727

112-04-5

PART NUMBER	OD	WALL	LENGTH +0.030 -0.000	ID	MATERIAL SPEC	NOTE
D3504-1	0.500	0.049	3.475	0.402 (REF)	M6061T6T0.500W.049	SEE NOTE 1a)
D3504-3	0.375	0.049	3.475	0.277 (REF)	M6061T6T0.375W.049	SEE NOTE 1a)
D3504-5	0.750	0.080 (REF)	3.400	0.590	M6061T6R0.750	SEE NOTE 1b)



D3504-1/-3/-5 CROSS BOLT SPACER:

- 1) MATERIAL: a) 6061-T6 OR 6061-T62 TUBING
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6TD.DDDW.TTT)
- b) 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6R0.750)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

RELEASED
07.11.16

C	ADD -5	DC	07.09.19
B	3.475 WAS 3.400	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>DC</i>		
CHECKED	<i>PH</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>PH</i>	D3504	SHEET 1 OF 1
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	CROSS BOLT SPACER	NTS
DATE	07.09.19	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Dart Aerospace Ltd

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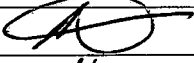

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

DART AEROSPACE LTD		Work Order:	82727
Description: Cross Bolt Spacer		Part Number:	D3504-5
Inspection Dwg: D3504 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.750	+0.008/-0.001	0.756	—		RA2G	Sum
0.080	+/-0.010	0.082	—		"	
3.400	+0.030/-0.000	3.405	—		"	
Ø0.590	+0.008/-0.001	0.596	—		"	

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	12-4-12	Date:	12/04/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD 	

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